

## ABSTRACT

A production method of a polyphase sequentially joined-segment coil of a rotary electric machine and a product  
5 produced by the same are provided. A production machine includes pairs of tines (160) working to catch heads of conductor segments (33) when they are twisted using rings (11) and (12). The tines (160) are designed to be rotatable about an axis of the rings following rotation of the rings to absorb stress acting on insulating  
10 coating on the heads of the segments to minimize rubbing of the insulating coatings, thereby ensuring a desired degree of electrical insulation of the stator coil.